

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007159**Date Inspected:** 13-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 6/13/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works (JSW), Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2W1 - Casting is in process moving by JSW Riggers, casting did not get finally located before end of shift of QA Inspector's shift.

W2W2 - Cast section is in Fabrication Shop #4 having had 2 of 4 lugs welded, one at each end of the casting. The built up plate portion, which is located adjacent its mating casting, is having bevels cut by way of Oxygen and Propane automated rig on tracks. JSW employee, Mr. K.Minami has completed all but 4 ribs plate. The process was not underway during QA Inspectors review of shop operations.

W2W3 - Saddle Casting is observed as idle in Foundry. During QA Inspector's observances JSW personnel were only grinding the reinforcement for inspection, both visual and NDT. No welding occurred during A Shift, on this plate section for W2W3.

TOWER SADDLES

T1-3 - Observations of QA Inspector were noted as follows: Repair of CJP joint 9Y-5U-2 had been completed and information relayed to QC CWI C.Kuan, from QC CWI M.Ashadi, was the weld parameters and welder information. Procedure used was SJ-3012-9 by K.Nakasato 91-2247, SMAW, E7016 4mm electrode. Upon

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WELDING INSPECTION REPORT

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Inspected By:	Brcic,Michael	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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